

Date: Monday, 9/17/2007 1:49:10 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206 EXTRUSION BENDING
Job Number	34692		
Estimate Number	10311		
P.O. Number	N/A	Part Number	D2620
This Issue	9/17/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2620 REV B
First Issue	N/A	Project Number	N/A
Previous Run	33880	Drawing Revision	B
Written By		Material	N/A
Checked & Approved By	HJ 07.09.17	Due Date	9/24/2007
Comment	Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF	Qty:	30
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26001160	Extrusion Round 3" 206	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) Extrusion Round 3" 206	
		Pick;	
	Qty	Part Number	Description
	1	D2600-1	Extrusion Round 3"206
			Batch 30249 SR
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008	
		2- Cut Fwd end of tube as per Dwg D2620	EL/SR AWM 07/09/18
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	7-9-18
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock	
		Location: 16	30
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	30 07/09/18
		Job Completion	 07/09/18

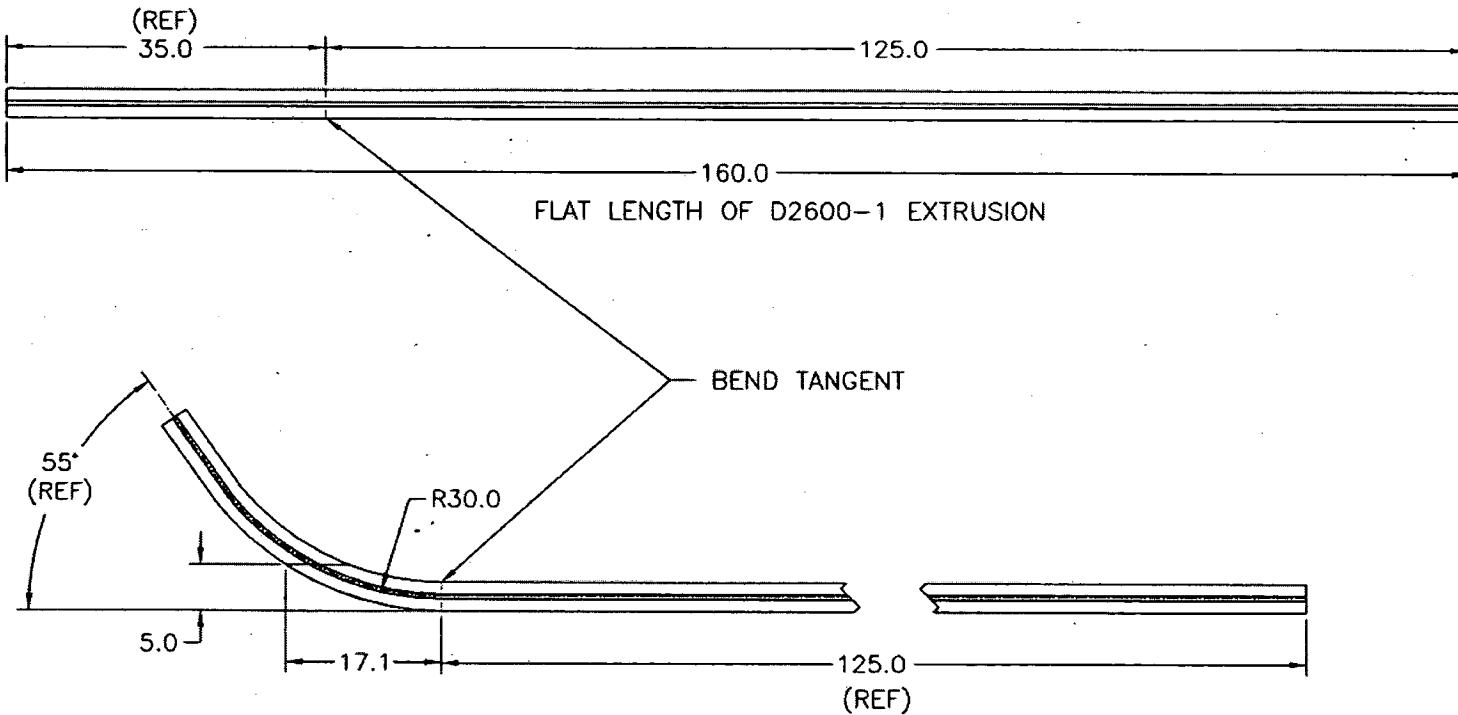
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2620 PAR #: N/A Fault Category: Pad Landing Gear NCR: Yes No DQA: D Date: 07/09/19
 QA: N/C Closed: S Date: 07.09.19

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.09.19	1.0	I 2 be was found w/ a big dent on the top. VERY visible.	J asial2	scraper, destruc. Replace B 30249 Qty 1	79-18	J 070919	J asial2	J 070919

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING
206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.20 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.20 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
 44-04-15
 DS

DART

COPY
dans

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
	RF	FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
99.09.10	AE	D2620	
DATE		TITLE	SCALE
A		206 SKIDTUBE BENDING CONTROL	1:20
B	97.11.07	NEW ISSUE	
	97.09.10	UPDATE FOR IN-HOUSE BENDING	

